

# Work Order ID 106485

\*106485\*

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Item ID: D3041-5 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Clamp  
 Start Date: 9/03/13 Start Qty: 40.00 \*40\* Cust Item ID:  
 Required Date: 9/09/13 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan: U Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D3041                          | Rev C                    |                      |         |        |              |               |               |                  |                |

100 BAND SAW 0.00  
 \*100\*  
 Bandsaw Memo 0.00  
 Jeaspa Bandsaw Cut D2423 Extrusion: 1.250" Long  
 cut @ meter

CL 13/09/103

110 HAAS CNC VERTICAL MACHINING #1 0.00  
 \*110\*  
 HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1 Check for cracks while loading into the machine  
 Machine as per Folio FA933  
 DWG REV: \_\_\_\_\_  
 FOLIO REV: \_\_\_\_\_  
 P/O 21174  
 issue P/O to meter  
 machine as per dwg

CL 13/09/103 40

120 QC2-Inspect parts off machine FA/FAIB 0.00  
 \*120\*  
 QC Memo 0.00  
 Quality Control  
 rec'd + inspect  
 attached cufc to w/o

13/9/19 (40)

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID               | Operation<br>Description  | Set Up/<br>Run Hours                     | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp   |
|--|---|--|---------|--------|--------------|---------------|---------------|------------------|------------------|
| 130<br>*130*<br>QC<br>Quality Control        | QC 8 - inspect parts - second check<br>Memo   | 0.00<br>DAS<br>27<br>9-89<br>0.00 B 9 20 |         |        |              | 40<br>can     |               |                  |                  |
| 140<br>*140*<br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br>Memo   | 0.00<br>0.00                             |         |        |              | 40            |               | HB B-9-23        |                  |
| 150<br>*150*<br>Powdercoat<br>Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum<br>Memo<br>START TIME: 8:00<br>FINISH TIME: 8:30 | 0.00<br>0.00                             |         |        |              |               |               |                  | 40xpm-f 13/09/24 |

m126125

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID         | Operation<br>Description                                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                    |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------------------------|
| 160<br>*160*<br>QC<br>Quality Control  | QC3- Inspect Part Finish<br><br>Memo                    | 0.00<br><br>0.00     |         |        |              |               |               |                  | 40x d 11/10/12                    |
| 170<br>*170*<br>Packaging<br>Packaging | Identify as per dwg & Stock Location: 57466<br><br>Memo | 0.00<br><br>0.00     |         |        |              |               |               |                  | 40x (28) 13-09-24                 |
| 180<br>*180*<br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo | 0.00<br><br>0.00     |         |        |              |               |               |                  | 10 / 2m 13/09/26<br>ME<br>13-9-25 |

# Picklist Print

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Work Order ID: 106485

Parent Item: D3041-5

Parent Item Name: Clamp

Start Date: 9/03/13

Required Date: 9/09/13

Start Qty: 40.00

Required Qty: 40.00

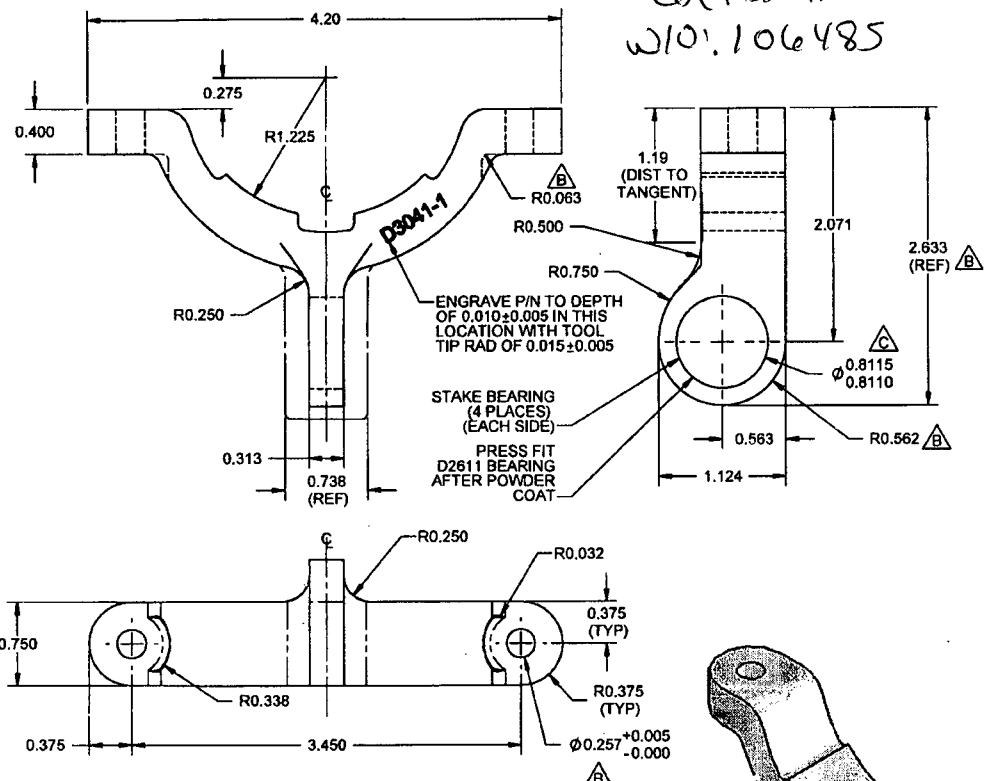
Comments: IPP: A01.07.11New IssueSM/EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D2423<br>Lug Extrusion          |                        | Manufactured  | No          |                     |                  |                 | f                  | 221.5000        |             | 4.08         |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | MAT006              |                  | 221.5           |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 87953               |                  | 221.5           |                    |                 |             |              |               |                |        |
| D3041-5P<br>Clamp               |                        | Purchased     | No          |                     |                  |                 | Each               | 0.0000          |             | 40           |               |                |        |

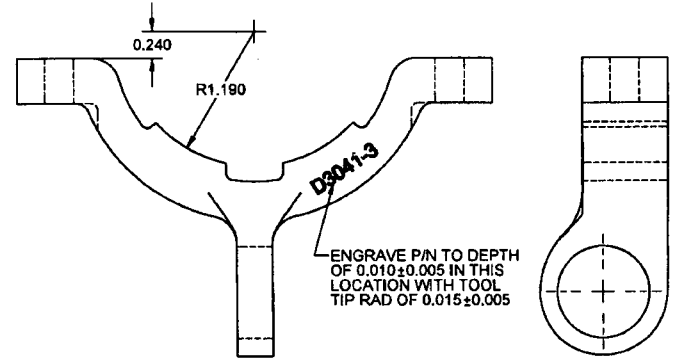
106485

13/9/13

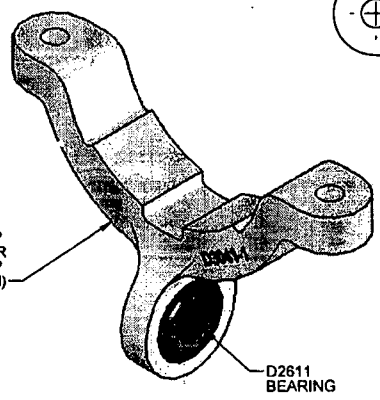
CL 13/09/05  
W10.106485



**D3041-1 CLAMP**



**D3041-3 CLAMP**  
(SAME AS D3041-1  
EXCEPT AS SHOWN)



D3041-1 CLAMP  
(SHOWN) OR  
D3041-3 CLAMP  
(NOT SHOWN)

- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.3.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
  - 6) STAKE D2611 BEARING AFTER POWDER COAT
  - 7) PART IS SYMMETRIC ABOUT C

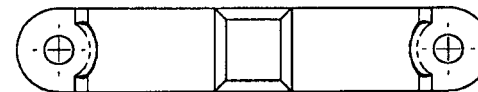
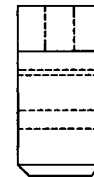
DEO ATTACHED

RELEASED

06.11.17

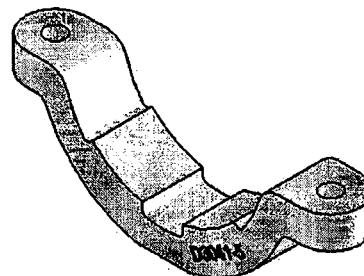
|  |          |  |
|--|----------|--|
| C  | 06.10.18 | CHANGED BEARING HOLE TOLERANCE                                   |
| B  | 06.06.05 | CHG TO RND END DETAIL, 0.063 WAS<br>0.032. ADD TOL. & D3041-5/-7 |
| A  | 01.06.28 | NEW ISSUE  |
| REV  | DATE     | DESCRIPTION  |
| DESIGN   | DRAWN BY | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA              |
| CHECKED  | APPROVED | DRAWING NO.<br><b>D3041</b>                                      |
| DATE   | 06.10.18 | TITLE<br><b>CLAMP</b>  |
| COPYRIGHT © 2001 BY DART AEROSPACE USA, INC.   |          | REV. C<br>SHEET 1 OF 2   |
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06.11.17 ~~th~~



**D3041-5 CLAMP** 

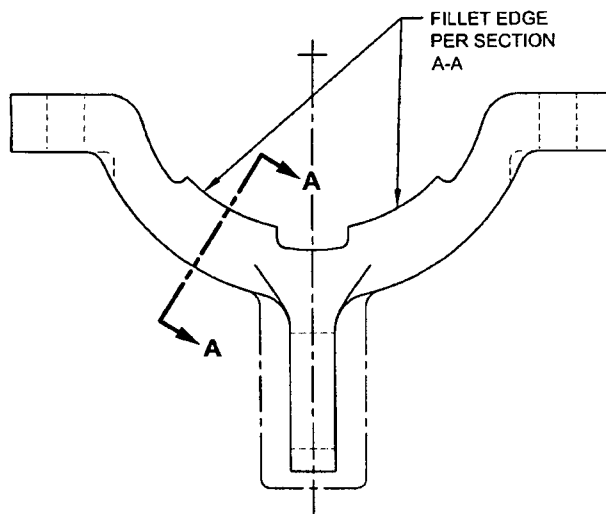
1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) COAT PER DART QSI 005 4.3  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED  
5) BREAK ALL SHARP CORNERS 0.010 TO 0.020  
6) PART IS SYMMETRIC ABOUT C



|   |                                |                                 |              |
|---|--------------------------------|---------------------------------|--------------|
| DESIGN<br><i>GP</i>   | DRAWN BY<br><i>CB</i>          | <b>DART AEROSPACE USA, INC.</b> |              |
| CHECKED<br><i>JB</i>  | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3041</b>     | REV. C       |
| DATE<br><b>06.10.18</b>   |                                | TITLE<br><b>CLAMP</b>           | SHEET 2 OF 2 |
| COPYRIGHT © 2001 BY DART AEROSPACE USA, INC.  |                                | SCALE<br><b>1:1</b>             |              |
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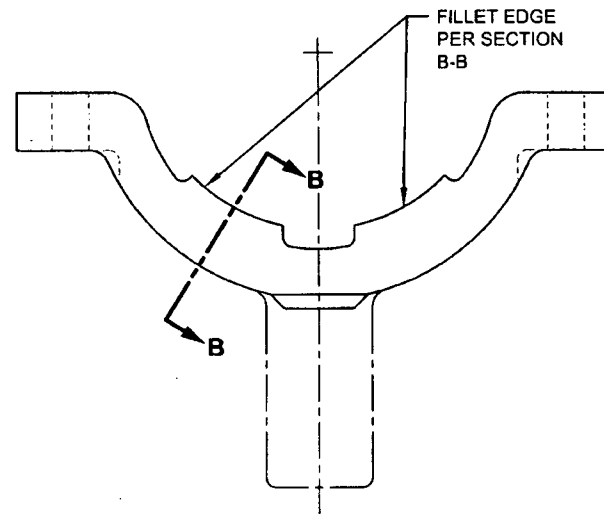
|                      |                  |                  |   |  |                         |                           |              |
|----------------------|------------------|------------------|---|--|-------------------------|---------------------------|--------------|
| DRAWING NO.<br>D3041 | TITLE<br>CLAMP   | REV: C           | DART AEROSPACE LTD<br>ENGINEERING ORDER |  | D.E.O. NO.<br>D3041-C-1 | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN<br>ADS         | CHECKED          | MFG. APPR.       | APPROVED                                |  | DE APPR.                |                           |              |
| DATE<br>09.03.04     | DATE<br>09.03.12 | DATE<br>09.03.12 | DATE<br>09.03.13                        |  | DATE<br>09.03.13        |                           |              |

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX  
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

**RELEASED**  
09/07/07

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20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 19488  
**Date:** Sep 18, 2013  
**Page:** 1

|  |  |
|--|--|
| <b>Sold to:</b>  | <b>Ship to:</b>  |
| <b>Dart Aerospace Ltd.</b><br>Att. Micheal Gregoire<br>1270 Aberdeen Street<br>Hawkesbury, Ontario K6A 1K7 | Dart Aerospace Ltd.<br>Att. Linda Lacelle<br>1270 Aberdeen Street<br>Hawkesbury, Ontario K6A 1K7 |
| <b>Order No.:</b> 21174  | <b>Sold By:</b> Dewar, Eric  |
| <b>Shipped By:</b> your truck  | <b>Ship Date:</b> Sep 18, 2013   |

| Description  | Unit | Ordered quantity          | Shipped quantity | Backorder quantity |
|--|------|---------------------------|------------------|--------------------|
| 3910-3 Crosstube Lug as per drawing D3910 REV.B  | Each | 24                        |                  | 24                 |
| D3041-5 Clamp as per drawing D3041-5P REV.C  | Each | 40                        | 40               |                    |
| D3041-7 Clamp as per drawing D3041 REV.C   | Each | 40                        |                  | 40                 |
| The delivered goods must be inspected upon receipt to confirm compliance.<br>Should there be discrepancies please notify METEC within 30 days of delivery.<br>The goods are otherwise deemed accepted. |      |                           |                  |                    |
| Received by _____  |      | Thank you for your order! |                  |                    |





20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0  
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

| <u>QUANTITY</u> | <u>PART NUMBER</u> | <u>PART NAME</u> | <u>P.O. NUMBER</u> |
|-----------------|--------------------|------------------|--------------------|
| 40              | D3041-5            | Lug              | PO 21174           |

MATERIAL: supplied by DART B87953

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris", is written over the company name.

Jan Norris

Vankleek Hill, September 18, 2013